

ASAP

Work Order ID 123278

123278

Page 1

Item ID: D4494-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Upper Block Assembly, RH

Stop

NS2

Start Date: 8/06/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/15/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4494

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 6.6" LONG

110

0.00

110

Purchasing

Memo

0.00

Purchasing

ISSUE P/O: 15345
TO ARCHUR PRECISION(GLOBUS)
C OF C IS REQUIRED

cm & 14/8/11

14/9/11

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

2

DAE
38
9-89

14-9-16

Work Order ID 123278

August-06-14 1:10:37 PM

123278

Page 2

Item ID: D4494-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Upper Block Assembly, RH

Stop ***NS2***

Start Date: 8/06/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/15/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

2 NG 14-8

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

2 ~~NG 14-8~~

141

Spray Painting per QSI005 4.2

0.00

141

SprayPaint

Memo

0.00

Spray Painting

PRIME TEMPO GREY

2 CR 14.09.18

M128923

August-06-14 1:10:37 PM

Page 3

[illegible]

Work Order ID 123278

August-06-14 1:10:37 PM

123278

Page 4

Item ID: D4494-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Block Assembly, RH
 Start Date: 8/06/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/15/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>St 230B</u>	0.00							
200									
Packaging	Memo	0.00				<u>2</u>	<u>MO</u>	<u>14/09/26</u>	
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00				<u>ML5</u>	<u>14-09-26</u>		
Quality Control									

MF 14-9-26

Picklist Print

August-06-14 1:10:36 PM

Page 1

Work Order ID: 123278

123278

Parent Item: D4494-042

D4494-042

Parent Item Name: Upper Block Assembly, RH

Start Date: 8/06/14

Required Date: 8/15/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-01-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-4		Purchased	No				Each	5,584.000		8			
--------------	--	-----------	----	--	--	--	------	-----------	--	---	--	--	--

MS20426AD3-4

RIVET

14/09/18

DAS
36
9-89

Location

Loc Qty

Loc Code

ST315

5584

125578

3066

m127432

2518

M6061T6B1.000X04.00

Purchased

No

f

102.2990

2

M6061T6B1.000X04.000

6061-T6 Bar 1.00 x 4.00

Location

Loc Qty

Loc Code

MAT003

102.299

124681

23.7

M126160

10

M127797

20.349

M128980

0.25

M129167

48

D4494-1P

Purchased

No

Each

0.0000

2

D4494-1P

Upper Block Lower Door, LH

2014/9/5

MAZEL supplied by Archer

2P

DAS
10
9-89

Picklist Print

August-06-14 1:10:36 PM

Page 2

Work Order ID: 123278

123278

Parent Item: D4494-042

D4494-042

Parent Item Name: Upper Block Assembly, RH

Start Date: 8/06/14

Required Date: 8/15/14

Start Qty: 2.00

Required Qty: 2.00

MS21059L08

Purchased

No

Each

735.0000

4

MS21059L 08

14/09/18

DAS

36

9-89

Nut

Location

Loc Qty

Loc Code

ST304

225

m129934

225

ST508

510

123185

1

125654

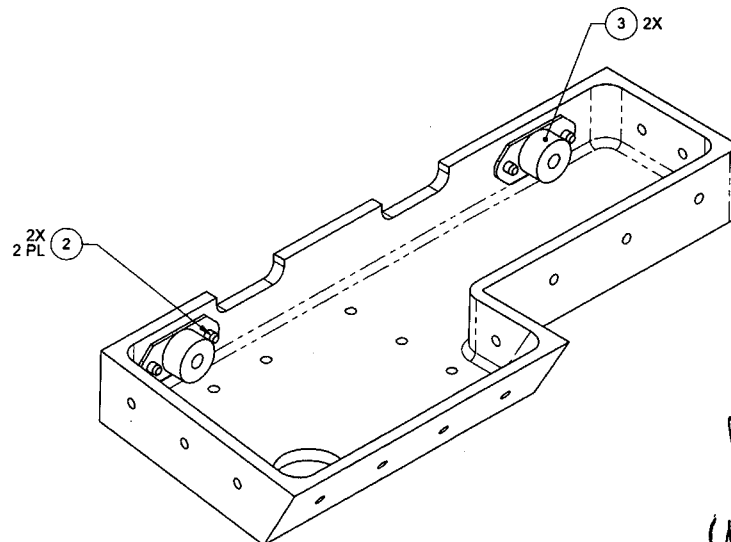
505

m124291

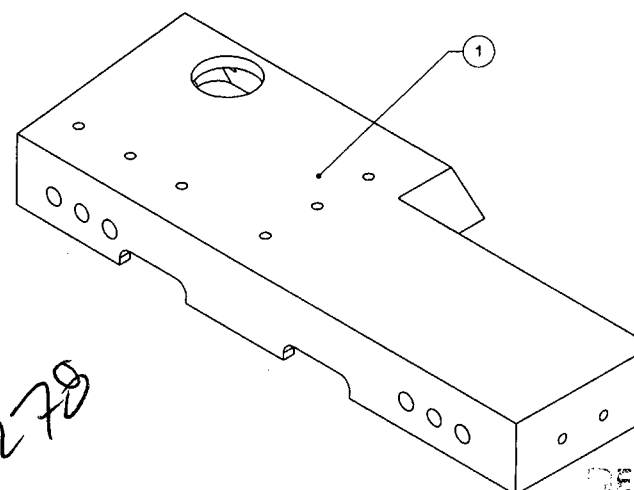
4

4

ITEM	QTY	P/N	DESCRIPTION
	X	D4494-041	UPPER BLOCK ASSEMBLY (LH)
1	1	D4494-1	UPPER BLOCK LOWER DOOR (LH)
2	4	MS20426AD3-4	RIVET, CSK
3	2	MS21059L08	NUTPLATE



D4494-041 UPPER BLOCK ASSEMBLY (LH)



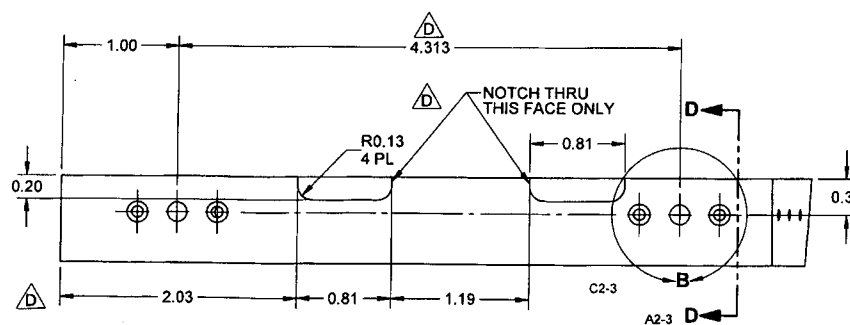
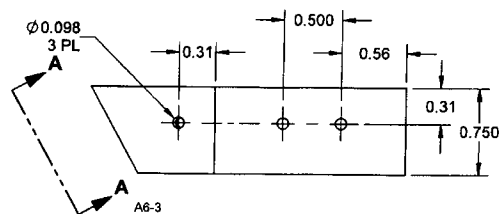
W/O 123278

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs

D	B4-2, 4.313 DIM WAS 4.000. NOTCHES ADDED. B5-5 4.313 DIM WAS 4.000. NOTCHES ADDED. REASON: LATCH MECHANISM RELOCATED AT NEXT ASSY. MODIFICATIONS DONE TO CLEAR NUTPLATES.	AJS	12.12.12
C	ADDED -042 & -2 (RH CONFIGURATION)	AJS	12.10.23
B	COMPLETE REDESIGN SEE REV. A FOR DETAILS. PRIMER NOTE ADDED.	AJS	12.09.13
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4494	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER BLOCK ASSEMBLY	NTS
DATE	12.12.12	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2013-02-14



1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

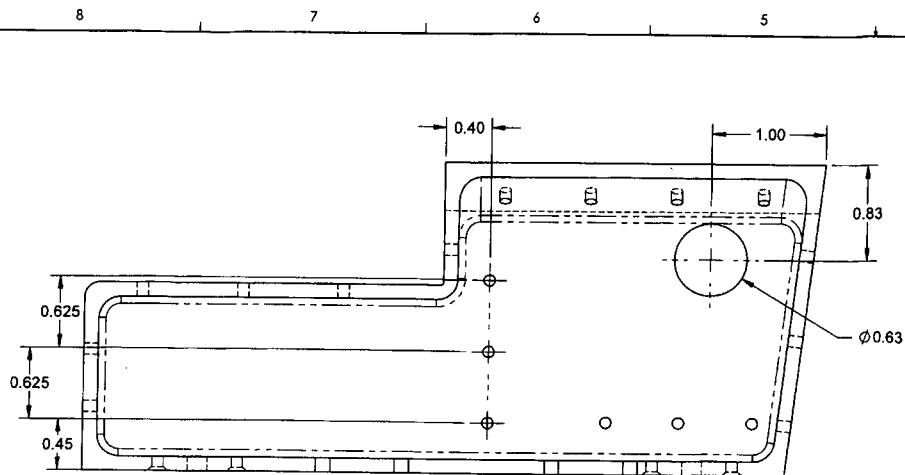
7) WEIGHT: 0.28 lbs

8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).

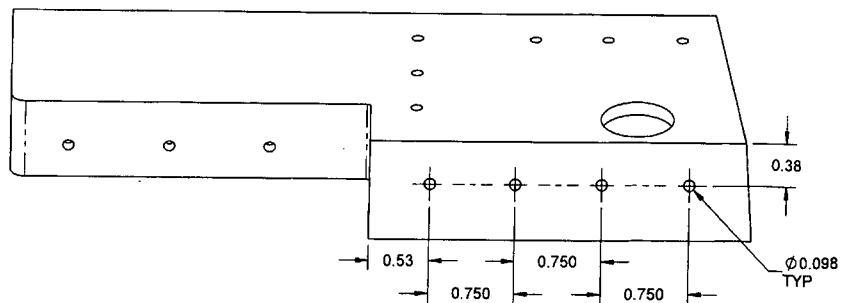
D4494-1 UPPER BLOCK LOWER DOOR (LH)

RELEASE
2013-02-14

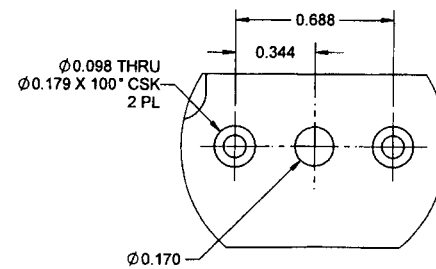
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4494 TITLE UPPER BLOCK ASSEMBLY <small> COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS HEREBY CONFIDENTIAL AND IS LOANED TO YOU BY THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR FIRM. </small>	REV. D
DRAWN	AJS		SHEET 2 OF 2
CHECKED	<i>A.P.</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE 12.12.12			



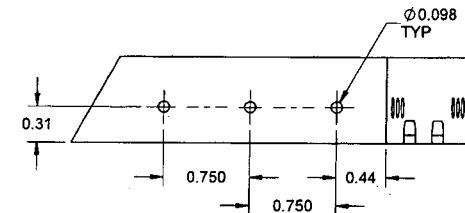
SUPPLEMENTAL VIEW



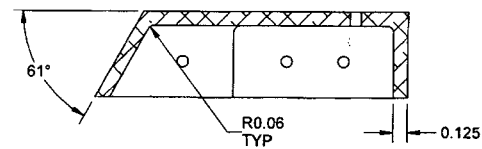
VIEW A-A B8-2



DETAIL B B3-2
NUPLATE HOLE DETAIL 2 PL
(SCALE 2X)



VIEW C-C C2-2

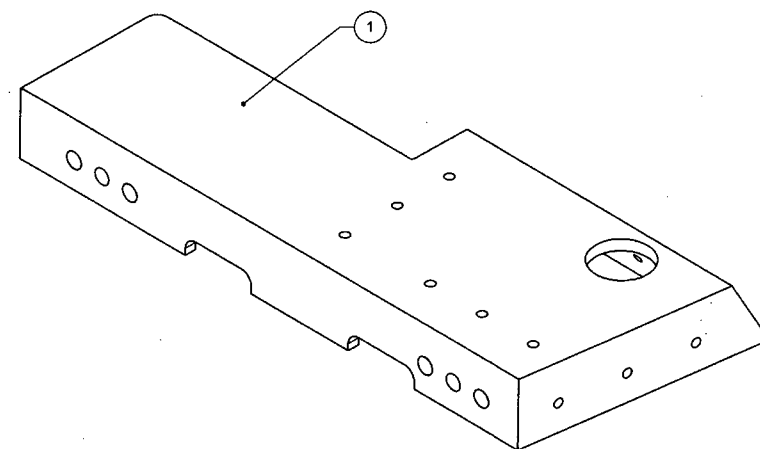
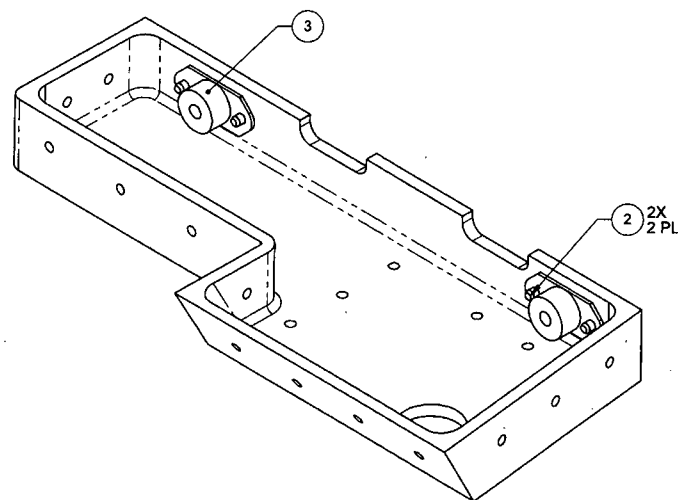


SECTION D-D B3-2

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2013-02-14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>AD</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>21</i>	D4494	SHEET 3 OF 6
APPROVED	<i>12</i>	TITLE	SCALE
DE APPR.	<i>12</i>	UPPER BLOCK ASSEMBLY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D4494-042	UPPER BLOCK ASSEMBLY (RH)
1	1	D4494-2	UPPER BLOCK LOWER DOOR (RH)
2	4	MS20426AD3-4	RIVET, CSK
3	2	MS21059L08	NUTPLATE



D4494-042 UPPER BLOCK ASSEMBLY (RH)

RELEASED
2013-02-14

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 0.30 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	AJS	D4494	SHEET 4 OF 6
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	UPPER BLOCK ASSEMBLY	NTS
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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

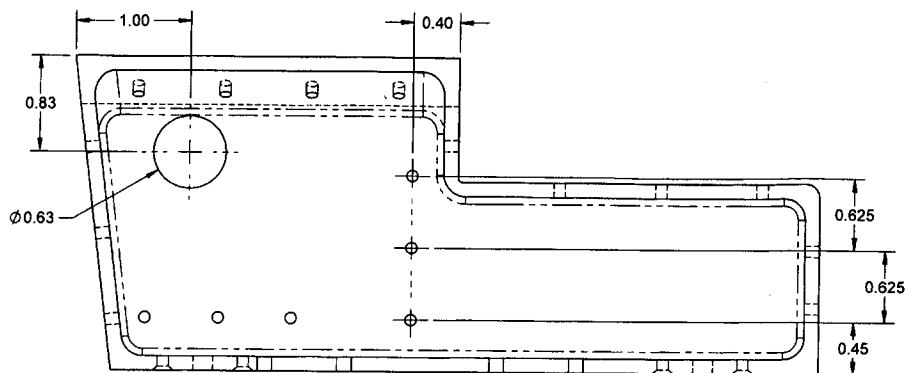
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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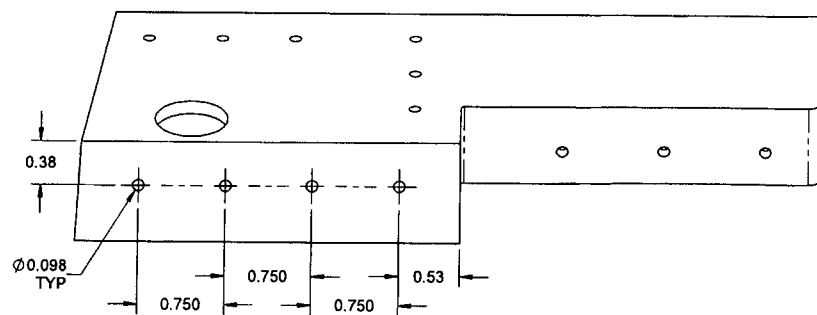
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

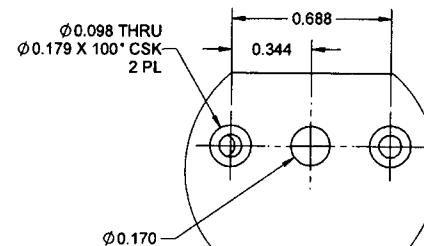
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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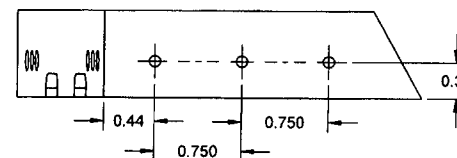
SUPPLEMENTAL VIEW



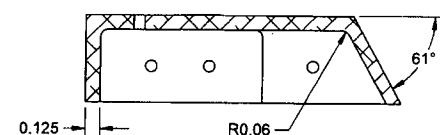
VIEW H-H B2-5



**DETAIL G B4-5
(SCALE 2X)**



VIEW F-F C7-5



SECTION E-E B6-5

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	21	D4494	SHEET 6 OF 6
APPROVED	12	TITLE	SCALE
DE APPR.	11	UPPER BLOCK ASSEMBLY	NTS
DATE	12.12.12	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2013-02-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25345**

Purchase Order Date 8/11/2014

PO Print Date 8/11/2014

Page Number 1 of 2

Order From :

VC-GLO001

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	d4476-042p Manufacture as per Drawing D4476 rev.B Batch 123279	Small Rib Assembly,RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$164.67	\$329.34
Line Total:							\$329.34
2	D4473-042P Manufacture as per Drawing D4473 rev.B Batch#123280	Smal Rib Assy, RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$164.67	\$329.34
Line Total:							\$329.34
3	D4494-042P Manufacture as per Drawing B4494 rev.D Batch# 123278	Upper Block Assy,RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$222.33	\$444.66

PO Instructions: Fedex Acc#151793240

Note:

8/11/2014



2228 Gladwin Crescent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
9/11/2014	1158

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
25345	9/11/2014	FedEx		

Qty	Item Code	Description
2	Sales	D4494-2P HST (ON) on sales



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

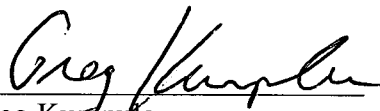
Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

11 September 2013

Po Number	Part Number	Quantities
25345	D4494-2P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 25345 issued by Dart Aerospace Inc.


Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6

Certificate of Mill Test Results

BL VIM-000000-000

Pg 1/1

PO/Rel

Noter: certifier que le document reproduit ici est
une copie conforme du rapport fourni par le
producteur du matériel ou les données résultant de

l'analyse faite par un laboratoire qualifié.
SIGNÉ PAR: _____
Atte:

PART NO.



Service Center Metals
5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

OUR ORDER NUMBER	ITEM
206123	4

MANIFEST NUMBER	DIE NUMBER	DATE OF SHIPMENT
227437	MRB1795	5/10/2014
CUSTOMER PO	ALLOY / TEMPER	SALESPERSON
PEC-258720	6061-T6511	David Schroeder
CUSTOMER PART NUMBER	DESCRIPTION	
MRB1795 X 240	MORB 1.000x4.000	

CERTIFICATION
ASTM-B221-13 Stencil Cont

SPECIFICATION
AMS-QQA-200/B - 1997

RoHS 2011/65/EU Compliant
Items produced and certified as 6061-T6511
also meet the requirements of 6061-T6

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA.

Mechanical Properties

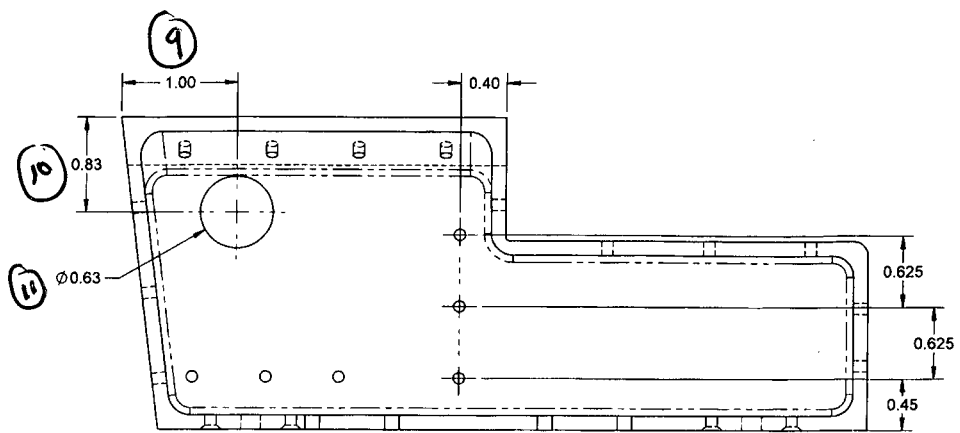
Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)		Yield Strength (KSI)		Percent Elongation	
1	201411210	6/7/14	min	max	min	max	min	max
			51.50	51.50	48.00	48.00	14.46	14.46

Chemical Composition for Aluminum Alloy 6061

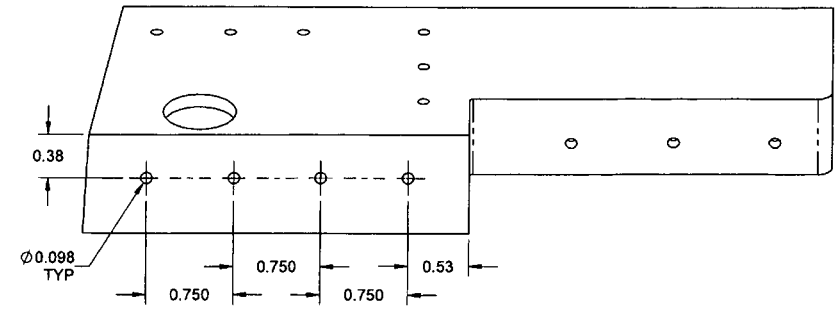
Cast Number	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al	Others Each	Total	Melt Source:
05271402	6061	0.73	0.34	0.31	0.13	0.84	0.15	0.05	0.02	97.43	0.03	0.10	United States of America

Print Date: 6/10/2014

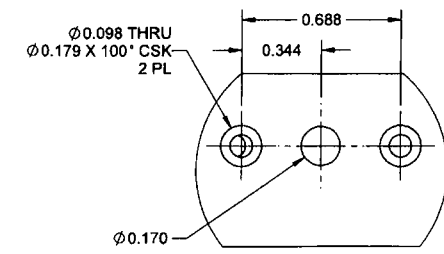
Calvin J. Wigglesworth, Director of Quality & Technical Services



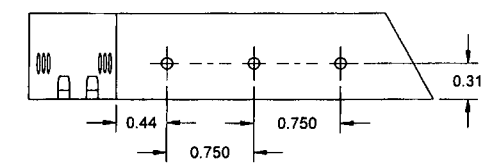
SUPPLEMENTAL VIEW



VIEW H-H B2-5

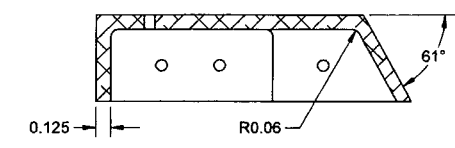


DETAIL G B4-5 (SCALE 2X)



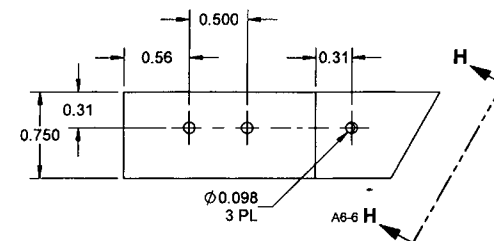
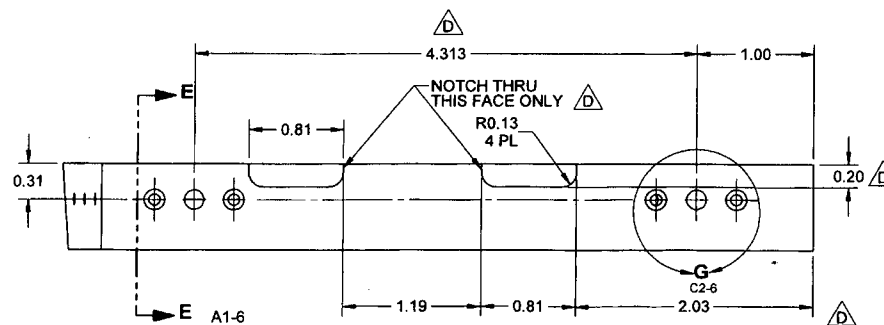
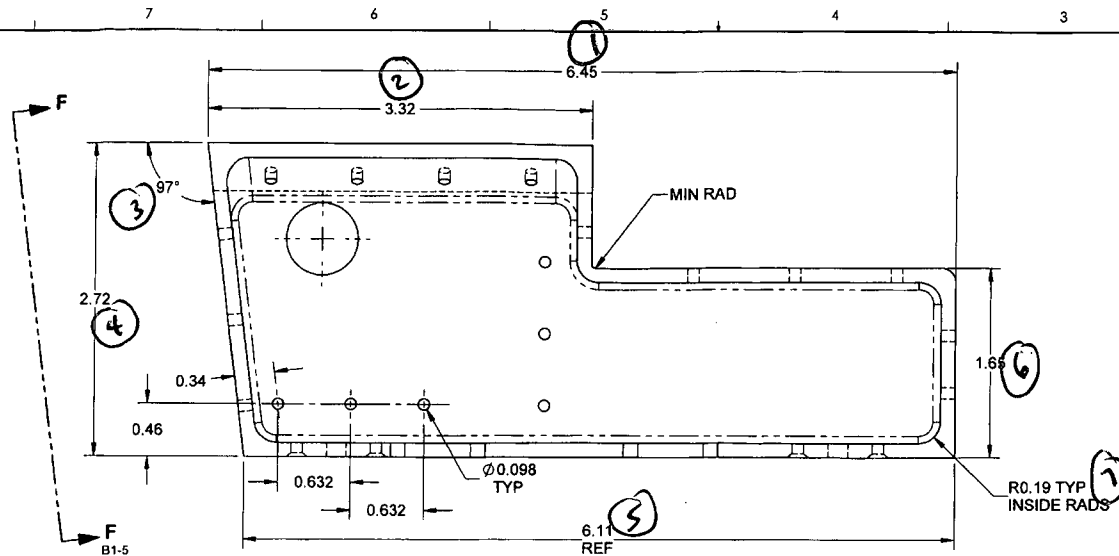
VIEW F-F C7-5

RELEASED
2013-02-14



SECTION E-E B6-5

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/1	D4494	SHEET 6 OF 6
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	UPPER BLOCK ASSEMBLY	NTS
DATE	12.12.12	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.28 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)

D4494-2 UPPER BLOCK LOWER DOOR (RH)

RELEASED
2013-02-14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. D4494	REV. D
MFG. APPR.	[Signature]	SHEET 5 OF 6	
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	UPPER BLOCK ASSEMBLY	NTS
DATE	12.12.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Archer Precision

Short date 9/10/14



Plan Name Mirror test D4494-1_RevD1 Part No.: D4494-2P
Customer: Dart Aerospace Rev.: D
u_jobnum * u_jobnum * u_qtynu * u_qtynu *
Customer PO.: * u_Cuspo * BSN:
u_mtl * u_mtl * Incr. Smpl No.: 1

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
■ 1 - OA Length	X	-6.44635	-6.44507	0.03000	-0.03000	-0.00128	-
■ 2 - Egde	X	-3.32020	-3.32007	0.03000	-0.03000	-0.00013	-
■ 3 - Angle of Side	A2	172.99599	173.00000	0.50000	-0.50000	-0.00401	-
■ 4 - OA Width	Y	2.71646	2.72137	0.03000	-0.03000	-0.00491	-
■ 5 - Length	CartDist	6.11219	6.11000	0.03000	-0.03000	0.00219	-
■ 6 - Egde	CartDist	1.64797	1.65000	0.03000	-0.03000	-0.00203	-
■ 7 - Exterior Radius	R	0.12516	0.12500	0.01000	-0.01000	0.00016	-
■ 8 - Interior Rad	R	0.18640	0.19000	0.01000	-0.01000	-0.00360	--
■ 9 - XPosition Hole1	X	-0.99737	-0.99688	0.03000	-0.03000	-0.00049	-
■ 10 - YPostion Hole1	Y	0.82544	0.82693	0.03000	-0.03000	-0.00149	-
□ 11 - Diam_ Hole1	D	0.62441	0.62500	0.00800	-0.00100	-0.00059	----
■ 12 - Angle Front	A2	-29.00823	-29.00000	0.50000	-0.50000	-0.00823	-
■ 13 - Thickness	CartDist	0.12580	0.12500	0.01000	-0.01000	0.00080	-
■ Pocket Depth	Z	-0.62507	-0.62500	0.01000	-0.01000	-0.00007	-